

Date: Wednesday, 2/15/2006 3:50:29 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: PLUG			
Job Number	: 25865							
Estimate Number	: 10512							
P.O. Number	: N/A			Part Number	: D26511			
This Issue	: 2/15/2006	S.O. No.	: N/A	Drawing Number	: D2651 REV. B			
Prsht Rev.	: NC			Project Number	: N/A			
First Issue	: N/A			Drawing Revision	: B			
Previous Run	: 25365			Material	: N/A			
Written By	: See Comments Below			Due Date	: 3/10/2006			
Checked & Approved By	: JAT 06.02.16				Qty:	300	Um:	Each
Comment	: Est: A 02.04.15 New Issue NG							
	: Est: B 05.12.12 added deburr EC							

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6R0500	6061-T6 Round Bar .500" 
		
	Comment: Qty.: 0.0421 f(s)/Unit Total : 12.6315 f(s) Material: 6061-T6 (QQ-A-225/8) 0.500" Dia (M6061T6R0500) Batch: <u>M19296</u>	MS 06/03/05
2.0	HARDINGE	HARDINGE CNC LATHE SMALL 
		
	Comment: HAAS CNC VERTICAL MACHINING #1 1- Turn as per Folio FA219 and Dwg D2651 2- Deburr	MS 06/03/05 308 MS 06/03/05
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
		
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	MS 06/03/05 308
4.0	QC8	SECOND CHECK 
		
	Comment: SECOND CHECK	MS 06/03/05 308
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
		
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr, as per dwg D2651	MS 06/03/05 308

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/07/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/15/2006 3:50:29 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: PLUG
Job Number: 25865		Part Number: D26511
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		SA0 06:05:13
7.0	POWDER COATING 	POWDER COATING 
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 (Only larger section necessary)		DL 06/07/14 #308
8.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT		IC 06/07/14 308
9.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FA 15		DL 06/07/14 308
10.0	DC 	DOCUMENT CONTROL 
Comment: DOCUMENT CONTROL Inspection Level 21		1A 06.07.17
Job Completion 		U 800707

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25865
Description: Plug	Part Number:	D2651-1
Inspection Dwg: D2651	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

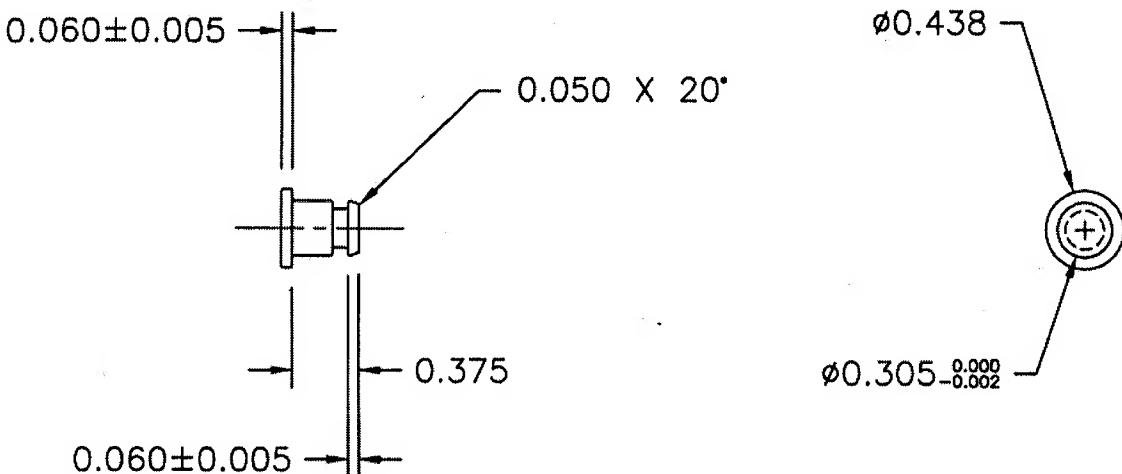
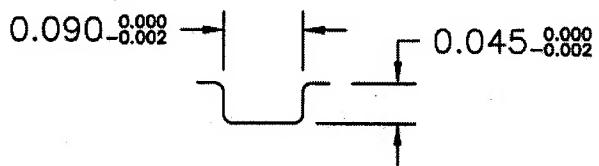
X First Article Prototype

Measured by:	MS	Audited by:	One	Prototype Approval:	N/A
Date:	06/03/05	Date:	06/03/06	Date:	—

Rev	Date	Change	Revised by	Approved
A	03.12.22	New Issue	KJ/RF	

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2651	SHEET 1 OF 1
DATE		TITLE	SCALE
03.12.19		PLUG	1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

RELEASED03.12.19 *[Signature]*D2651-1 PLUG:GROOVE DETAIL (SCALE 5:1)D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE ~~NOTED~~
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 25865

Copyright © 1997 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
 OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.